Amendments To The Claims:

Claim 1 (original). A flexible, biaxially stretched, heat shrinkable polymeric film having at least one layer comprising a blend of at least three copolymers comprising:

20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester, an alkyl acrylate, acrylic acid, or methacrylic acid; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers; and wherein said film has a maximum ram puncture force of at least 70 Newtons, a ram puncture stress of at least 110 MPa, and a tear propagation strength "x" such that $10 \leq x \leq 40$ grams per mil in each of the machine and transverse directions or $x < 25$ grams per mil in at least one of the machine and transverse directions.

Claim 2 (original). A film, as defined in Claim 1, wherein said first polymer has a melting point of 80 to 92°C.

Claim 3 (original). A film, as defined in Claim 1, wherein said first polymer is a bipolymer.

Claim 4 (original). A film, as defined in Claim 1, wherein said first polymer is a terpolymer of: ethylene, butene-1 and hexene-1 or ethylene, hexene-1, octene-1.

Claim 5 (original). A film, as defined in Claim 1, wherein said second polymer comprises a copolymer of ethylene and octene-1.

Claim 6 (previously presented). A film, as defined in Claim 1, wherein said third polymer is selected from the group consisting of ethylene vinyl acetate copolymer, ethylene methylacrylate copolymer, ethylene butylacrylate copolymer, ethylene ethylacrylate copolymer, ethylene acrylic acid copolymer, and ethylene methacrylic acid copolymer.

Claim 7 (original). A film, as defined in Claim 1, wherein said third polymer comprises a copolymer of ethylene and vinyl acetate.

Claim 8 (original). A film, as defined in Claim 1, further comprising a fourth polymer having a melting point of 80 to 110°C.

Claim 9 (original). A film, as defined in Claim 1, having a haze value of less than 10%.

Claim 10 (original). A film, as defined in Claim 1, wherein said film has a tear propagation strength of 15 to 25 g/mil in at least one of the machine and transverse directions.

Claim 11 (original). A film, as defined in Claim 1, wherein said film has a shrinkage value at 90°C of at least 45% in at least one of the machine and transverse directions.

Claim 12 (original). A film, as defined in Claim 1, wherein said film has a total energy at maximum puncture force of at least 0.60 Joule.

Claim 13 (original). A film, as defined in Claim 1, wherein said film has a total energy at maximum puncture force of at least 0.90 Joule.

Claim 14 (original). A film, as defined in Claim 1, wherein said film has a maximum ram puncture force of at least 90 Newtons.

Claim 15 (original). A film, as defined in Claim 1, wherein said film has a maximum ram puncture force of at least 100 Newtons.

Claim 16 (original). A film, as defined in Claim 1, wherein said film has a maximum ram puncture force of at least 110 Newtons.

Claim 17 (original). A film, as defined in Claim 1, wherein said film has a ram puncture stress of at least 140 MPa.

Claim 18 (original). A film, as defined in Claim 1, wherein said first polymer has a $\overline{M}_w/\overline{M}_n$ of 1.5 to 3.0.

Claim 19 (original). A film, as defined in Claim 1, wherein said first polymer has a $\overline{M}_w/\overline{M}_n$ of 2.2 to 2.6.

Claim 20 (original). A film, as defined in Claim 1, wherein said first polymer has a melt index of 1.5 to 3.0 dg/min.

Claim 21 (original). A film, as defined in Claim 1, wherein said first polymer has a melt index of 0.3 to 1.5 dg/min.

Claim 22 (original). A film, as defined in Claim 1, further comprising at least three additional polymeric layers.

Claim 23 (previously presented). A film, as defined in Claim 1, wherein said layer comprising a blend has been irradiatively crosslinked.

Claim 24 (previously presented). A film, as defined in Claim 1, wherein said film forms a tube having an inner heat sealing layer comprising said blend.

Claim 25 (original). A film, as defined in Claim 1, wherein said film is fabricated into bags.

Claim 26 (original). A film, as defined in Claim 1, further comprising a gas barrier layer and said film has an oxygen transmission rate of less than 15 cc/100 in^2 for 24 hrs. at 1 atm.

Claim 27 (original). A film, as defined in Claim 1, wherein said blend comprises at least 50 percent by weight of said layer based on the total weight of the layer.

Claim 28 (original). A film, as defined in Claim 1, wherein said first polymer is present in an amount of 25 to 45 weight percent, based upon the total weight of the first, second and third polymers.

Claim 29 (original). A film, as defined in Claim 1, wherein said first polymer is present in an amount of 30 to 40 weight percent, based upon the total weight of the first, second and third polymers.

Claim 30 (original). A film, as defined in Claim 1, wherein said first polymer is present in an amount of 45 to 85 weight percent, based upon the total weight of the first, second and third polymers.

Claim 31 (original). A film, as defined in Claim 1, wherein at least one of said first, second, and third polymers comprises an interpolymer.

Claim 32 (original). A film, as defined in Claim 1, wherein at least one interpolymer comprises said first and second polymers.

Claim 33 (previously presented). A film, as defined in Claim 22, wherein said film comprises:

a first heat sealing surface layer comprising a polymer selected from the group consisting of: (a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60 wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

a second intermediate layer;

a third core layer comprising at least 80% by weight, based on said third layer's weight, of at least one copolymer of vinylidene chloride with from 2 to 20 weight percent, based on said copolymer's weight, of vinyl chloride or methyl acrylate; and

a fourth surface layer;

wherein at least one of said second and said fourth layers comprise a blend of at least three copolymers comprising:

20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester, an alkyl acrylate, acrylic acid, or methacrylic acid; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers; and wherein said film has a maximum ram puncture force of at least 70 Newtons, a ram puncture stress of at least 110 MPa, and a tear propagation strength "x" such that $10 \leq x \leq 40$ grams per mil in each of the machine and transverse directions or $x < 25$ grams per mil in at least one of the machine and transverse directions; and said core layer is disposed between said second and said fourth layers.

Claim 34 (original). A film, as defined in Claim 33, wherein said film has a shrinkage value at 90°C of at least 40% in at least one of the machine and transverse directions.

Claim 35 (original). A film, as defined in Claim 33 or 34, wherein said film has a tensile seal strength of at least 400 g/cm at 88°C.

Claim 36 (original). A film, as defined in Claim 33, wherein said film has a tensile seal strength of at least 600 g/cm at 88°C.

Claim 37 (original). A film, as defined in Claim 33 or 34, wherein said film has a hot water puncture resistance value of at least 40 seconds at 95°C.

Claim 38 (original). A film, as defined in Claim 33, wherein said film has a hot water puncture resistance value of at least 100 seconds at 95°C.

Claim 39 (original). A film, as defined in Claim 33 or 34, wherein said film has an average hot water seal strength of at least 200 seconds at 95°C.

Claim 40 (original). A film, as defined in Claim 33 or 34, wherein said film has an average hot water seal strength of at least 300 seconds at 95°C.

Claim 41 (original). A film, as defined in Claim 1 or 33, wherein said film has a ram puncture stress of at least 275 MPa.

Claim 42 (original). A film, as defined in Claim 33, wherein said melting point of said first heat sealing surface layer polymer (b) is at least 115°C.

Claim 43 (previously presented). A biaxially stretched, heat shrinkable film comprising at least three layers, a first layer comprising a blend of at least three polymers comprising: a first polymer having a melting point of 80 to 98°C comprising a copolymer of ethylene and hexene-1; a second polymer having a melting point of 115 to 128°C comprising a copolymer of ethylene and at least one α-olefin; a third polymer having a melting point of 60 to 110°C comprising a copolymer ethylene and a vinyl ester or alkyl acrylate; a third layer comprising at least 50 percent by weight of copolymer of ethylene with at least one alpha-olefin or at least one vinyl ester or blends thereof, and a second layer comprising a vinylidene chloride copolymer, a nylon or a copolymer of ethylene with a vinyl alcohol; said film having a ram puncture force of at least 70 Newtons, a ram puncture stress of at least 110 MPa, and a tear propagation strength "x" such that $10 \leq x \leq 40$ grams per mil in each of the machine and transverse directions or $x < 25$ grams per mil in at least one of the machine and transverse directions.

Claim 44 (original). A flexible, thermoplastic, biaxially stretched, heat shrinkable film having at least one layer comprising a blend of at least three copolymers comprising:

45 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers; and wherein said film has a maximum ram puncture force of at least 120 Newtons.

Claim 45 (previously presented). A film, as defined in Claim 44, wherein said maximum ram puncture force is at least 150 Newtons.

Claim 46 (previously presented). A film, as defined in Claim 44, wherein said maximum ram puncture force is at least 200 Newtons.

Claim 47 (original). A film, as defined in Claim 44, wherein said film has a total energy absorption of at least 1.20 Joules.

Claim 48 (original). A film, as defined in Claim 44, wherein said film has a total energy absorption of at least 1.50 Joules.

Claim 49 (original). A film, as defined in Claim 44, wherein said film has a total energy absorption of at least 2.0 Joules.

Claim 50 (original). A film, as defined in Claim 44, wherein said film has a maximum stress of at least 150 MPa.

Claim 51 (original). A film, as defined in Claim 44, wherein said film has a maximum stress of at least 275 MPa.

Claim 52 (original). A film, as defined in Claim 44, wherein at least one of said first, second, and third polymers comprises an interpolymer.

Claim 53 (original). A film, as defined in Claim 44, further comprising at least four additional thermoplastic layers.

Claim 54 (previously presented). A film, as defined in Claim 44, wherein said film comprises:

a first heat sealing surface layer comprising a polymer selected from the group consisting of: (a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60 wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

a second intermediate layer;

a third core layer comprising at least 80% by weight, based on said third layer's weight, of at least one copolymer of vinylidene chloride with from 2 to 20 weight percent, based on said copolymer's weight, of vinyl chloride or methyl acrylate; and

a fourth surface layer;

wherein at least one of said second and said fourth layers comprise said blend of at least three copolymers, and said core layer is disposed between said second and said fourth layers.

Claim 55 (previously presented). A film, as defined in Claim 54, wherein said film has a shrinkage value at 90°C of at least 40% in at least one of the machine and transverse directions.

Claim 56 (original). A film, as defined in Claim 54 or 55, wherein said film has a tensile seal strength of at least 400 g/cm at 88°C.

Claim 57 (original). A film, as defined in Claim 54, wherein said film has a tensile seal strength of at least 600 g/cm at 88°C.

Claim 58 (original). A film, as defined in Claim 54 or 55, wherein said film has a hot water puncture resistance value of at least 40 seconds at 95°C.

Claim 59 (original). A film, as defined in Claim 54, wherein said film has a hot water puncture resistance value of at least 100 seconds at 95°C.

Claim 60 (original). A film, as defined in Claim 54 or 55, wherein said film has an average hot water seal strength of at least 200 seconds at 95°C.

Claim 61 (original). A film, as defined in Claim 54 or 55, wherein said film has an average hot water seal strength of at least 300 seconds at 95°C.

Claim 62 (original). A film, as defined in Claim 54, wherein said film has a ram puncture stress of at least 275 MPa.

Claim 63 (original). A film, a s defined in Claim 54, wherein said melting point of said first heat sealing surface layer polymer (b) is at least 115°C.

Claim 64 (previously presented). A biaxially stretched, heat shrinkable film comprising at least three layers, wherein said first layer comprises a blend of at least three polymers comprising: a first polymer having a melting point of 80 to 98°C comprising a copolymer of ethylene and hexene-1; a second polymer having a melting point of 115 to 128°C comprising a copolymer of ethylene and at least one α-olefin; a third polymer having a melting point of 60 to 110°C comprising a copolymer ethylene and a vinyl ester or alkyl acrylate; a third layer comprising at least 50 percent by weight of copolymer of ethylene with at least one alpha-olefin or at least one vinyl ester or blends thereof, and a second layer between said first and third layers; said second layer comprising a vinylidene chloride copolymer, a nylon or a copolymer of ethylene with a vinyl alcohol; said film having a maximum ram puncture force of at least 120 Newtons, and a total energy absorption of at least 1.20 Joules.

Claim 65 (previously presented). A film, as defined in Claim 64, wherein said maximum ram puncture force is at least 150 Newtons.

Claim 66 (previously presented). A film, as defined in Claim 64, wherein said maximum ram puncture force is at least 200 Newtons.

Claim 67 (original). A film, as defined in Claim 64, wherein said film has a total energy absorption of at least 1.50 Joules.

Claim 68 (original). A film, as defined in Claim 64, wherein said film has a total energy absorption of at least 2.0 Joules.

Claim 69 (original). A film, as defined in Claim 64, wherein at least one of said first, second, and third polymers comprises an interpolymer.

Claim 70 (original). A film, as defined in Claim 64, wherein at least one interpolymer comprises said first and second polymers.

Claim 71 (original). A film, as defined in Claim 64, wherein said first layer is a surface heat sealing layer.

Claim 72 (cancelled).

Claim 73 (cancelled).

Claim 74 (cancelled).

Claim 75 (cancelled).

Claim 76 (currently amended). ~~A blend, as defined in Claim 72,~~ A polymer blend of at least three copolymers consisting essentially of:

20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin;

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate;

wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers; and

wherein at least one of said first, second, and third polymers comprises an interpolymer.

Claim 77 (currently amended). A blend, as defined in Claim ~~72~~ 76, wherein said first and second polymers comprises an interpolymer.

Claim 78 (cancelled).

Claim 79 (currently amended). A flexible film, ~~as defined in Claim 78,~~ wherein said film comprises:

a heat sealing surface layer comprising a polymer selected from the group consisting of: (a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60 wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

an intermediate layer;

a core layer;

an outer protective surface layer;

wherein at least one of said intermediate and said outer protective layers comprise ~~said polymer blend of at least three copolymers,~~ a polymer blend of at least three copolymers consisting essentially of:

20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexane-1;

5 to 35 weight percent of a second polymer having a melting point of 115 of 128°C comprising at least one copolymer of ethylene and at least one α-olefin;

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate;

wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers; and said core layer is disposed between said intermediate and said outer protective layers, and said film has a hot water seal strength of at least 200 seconds at 95°C.

Claim 80 (cancelled).

Claim 81 (cancelled).

Claim 82 (previously presented). A process for making biaxially stretched, heat shrinkable film comprising:

extruding a melt plastified primary tube comprising 20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

cooling said primary tube;

reheating said cooled tube to a draw point temperature of 68 to 88°C;

biaxially stretching said tube to provide a transverse direction circumference of at least 2½ times the circumference of said primary tube and a machine direction length of at least 2½ times the length of a corresponding segment of said primary tube, and cooling said biaxially stretched tube to form a biaxially stretched, heat shrinkable film having a film thickness less than 10 mil (254 microns), wherein said resultant film has a ram puncture force of at least 70 Newtons, a ram puncture stress of at least 110 MPa, and a tear propagation strength "x" such that $10 \leq x \leq 40$ grams per mil in each of the machine and transverse directions or $x < 25$ grams per mil in at least one of the machine and transverse directions.

Claim 83 (previously presented). A process for making biaxially stretched, heat shrinkable film comprising:

extruding a melt plastified primary tube comprising 20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

cooling said primary tube;

reheating said cooled tube to a draw point temperature of 68 to 88°C;

biaxially stretching said tube to provide a transverse direction circumference of at least 2½ times the circumference of said primary tube and a machine direction length of at least 2½ times the length of a corresponding segment of said primary tube, and cooling said biaxially stretched tube to form a biaxially stretched, heat shrinkable film having a film thickness less than 10 mil (254 microns), wherein

said resultant film has a ram puncture force of at least 120 Newtons, and a total energy absorption of at least 1.20 Joules.

Claim 84 (cancelled).

Claim 85 (cancelled).

Claim 86 (currently amended). ~~A process, as defined in Claim 80,~~ A process for making biaxially stretched, heat shrinkable film comprising a polymeric blend A comprising:

extruding a melt plastified primary tube comprising 20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin;

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

cooling said primary tube;

reheating said cooled tube to a draw point temperature of 65 to 88°C;

biaxially stretching said tube to provide a transverse direction circumference of at least 2½ times the circumference of said primary tube and a machine direction length of at least 2½ times the length of a corresponding segment of said primary tube, and cooling said biaxially stretched tube to form a biaxially stretched, heat shrinkable film having a film thickness less than 10 mil (254 microns);

wherein a multilayer primary tube is made by coextrusion or coating lamination and said resultant biaxially stretched film comprises:

a heat sealing surface layer comprising a polymer selected from the group consisting of: (a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60 wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

an intermediate layer;

a core layer comprising at least 80% by weight, based on said third layer's weight, of at least one copolymer of: EVOH; or vinylidene chloride with from 2 to 20 weight percent, based on said copolymer's weight, of vinyl chloride or methyl acrylate;

an outer protective surface layer;

wherein at least one of said intermediate and said outer protective layers comprise said polymeric blend A, and said core layer is disposed between said intermediate and said outer protective layers, and said film has a maximum ram puncture force of at least 100 Newtons, a hot water puncture resistance of at least 100 seconds at 95°C and a hot water seal strength of at least 200 seconds at 95°C.

Claim 87 (previously presented). A biaxially stretched, heat shrinkable, multilayer film useful for food processing and packaging having at least four layers comprising:

a first heat sealing surface layer comprising a polymer or blend of polymers selected from the group consisting of: (a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60 wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

a second polymeric layer comprising (a) from 10 to 85 wt. % of a first copolymer of ethylene and at least one C_3-C_8 α-olefin, said first copolymer having a melting point of 55 to 98 °C; (b) from 5 to 60 wt. % of a second copolymer of ethylene and at least one C_4-C_8 α-olefin, said second copolymer having a melting point of 115 °C to 128 °C, (c) from 0 to 50 wt. % of a third copolymer having a melting point of 60 to 110°C of ethylene with a vinyl ester or alkyl acrylate, wherein said first and second copolymers have a combined weight percentage of at least 50 weight percent, said weight percent being based upon the total weight of said layer;

a third layer comprising at least 80% by weight, based on said third layer's weight, of at least one copolymer of vinylidene chloride with from 2 to 20 weight percent, based on said copolymer's weight, of vinyl chloride or methyl acrylate; and

a fourth polymeric layer comprising (a) from 10 to 85 wt. % of a first copolymer of ethylene and at least one C_3-C_8 α-olefin, said first copolymer having a melting point of 55 to 98°C; (b) from 5 to 60 wt. % a second copolymer of ethylene and at least one C_4-C_8 α-olefin, said second copolymer having a melting point of 115 °C to 128 °C, and (c) from 0 to 50 wt. % of a third copolymer having a melting point of 60 to

110 °C of ethylene with a vinyl ester or alkyl acrylate , wherein said first and second copolymers have a combined weight percentage of at least 50 weight percent, said weight percent being based upon the total weight of said layer; and

wherein said film has a shrinkage value at 90 °C of at least 40% in at least one of the machine and transverse directions, and said film has a tensile seal strength of at least 400 g/cm at 88 °C.

Claim 88 (original). A film, as defined in Claim 87, wherein said film has a maximum ram puncture force of at least 70 Newtons.

Claim 89 (original). A film, as defined in Claim 87, wherein said film has a maximum ram puncture force of at least 110 Newtons.

Claim 90 (original). A film, as defined in Claim 87, 88 or 89, wherein said film has a hot water puncture resistance of at least 20 seconds at 95 °C.

Claim 91 (original). A film, as defined in Claim 87, wherein said film has a hot water puncture resistance of at least 40 seconds at 95 °C.

Claim 92 (original). A film, as defined in Claim 87 or 88, wherein said film has a hot water puncture resistance of at least 60 seconds at 95 °C.

Claim 93 (original). A film, as defined in Claim 87 or 89, wherein said film has a hot water puncture resistance of at least 100 seconds at 95 °C..

Claim 94 (original). A film, as defined in Claim 87, 88 or 89, wherein said film has a hot water seal strength of at least 200 seconds at 95 °C.

Claim 95 (original). A film, as defined in Claim 87, 88 or 89, wherein said film has a hot water seal strength of at least 300 seconds at 95 °C.

Claim 96 (original). A film, a s defined in Claim 87, wherein said melting point of said first heat sealing surface layer polymer (b) is at least 115 °C.

Claim 97 (original). A film, as defined in Claim 87, wherein said film has a thickness less than 175 microns.

Claim 98 (original). A film, as defined in Claim 87, wherein said film has a thickness between 50 to 150 microns.

Claim 99 (original). A film, as defined in Claim 87, wherein said film has a haze value of less than 10% and a gloss at 45° of at least 70 Hunter units.

Claim 100 (original). A film, as defined in Claim 87, wherein said film has an oxygen transmission rate of less than 45 cm^3/m^2 for 24 hrs. at 1 atm. at 23 °C.

Claim 101 (original). A film, as defined in Claim 87, wherein said first copolymer of at least one of said second and fourth layers has a density less than 0.900 g/cm^3.

Claim 102 (original). A film, as defined in Claim 87, wherein said first copolymer of both said second and fourth layers has a density less than 0.900 g/cm^3.

Claim 103 (previously presented). A film, as defined in Claim 87, wherein said third copolymer of both said second and fourth layers comprises 4 to 18%, by weight of said copolymer, of a vinyl ester or alkyl acrylate.

Claim 104 (previously presented) A film, as defined in Claim 87, wherein: (a) in at least one of said second and fourth polymeric layers said first copolymer comprises at least one copolymer having a melting point of 80 to 98°C of ethylene and hexene-1 and is present in an amount of from 20 to 85 weight percent, based upon the weight of the layer containing said first copolymer and wherein (b) said second copolymer has a melting point of 115 to 128°C and is present in an amount of 5 to 35 weight percent based upon the weight of the layer containing said second copolymer; and (c) said third polymer having a melting point of 60 to 110°C is present in an amount of 10 to 50 weight percent, based upon the weight of the layer containing said third polymer.

Claim 105 (original). A film, as defined in Claim 87, wherein both of said second and fourth polymeric layers comprise:

(a) 20 to 85 weight percent of a first copolymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

(b) 5 to 35 weight percent of a said second copolymer having a melting point of 115 to 128°C; and

(c) 10 to 50 weight percent of said third polymer having a melting point of 60 to 110°C.

Claim 106 (original). A film, a s defined in Claim 42, 63, or 96, wherein said melting point of said first heat sealing surface layer polymer (b) is at least 115°C.

Claim 107 (previously presented). A film, as defined in Claim 104 or 105, wherein said copolymer of ethylene and hexene-1 is present in an amount of 45 to 85 wt. %.

Claim 108 (previously presented). A film, as defined in Claim 104 or 105, wherein said copolymer of ethylene and hexene-1 is present in an amount of 20 to 45 wt. %.

Claim 109 (previously presented). A polymer blend of at least three copolymers comprising:

20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 of 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate;

wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

wherein at least one of said first, second, and third polymers comprises an interpolymer.

Claim 110 (previously presented). A blend, as defined in Claim 109, wherein said first and second polymers comprises an interpolymer.

Claim 111 (previously presented). A flexible film comprising:

a heating sealing surface layer comprising a polymer selected from the group consisting of:

(a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof and said polymer having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

an intermediate layer;

a core layer;

an outer protective surface layer;

wherein at least one of said intermediate and said outer protective layers comprise a polymer blend of at least three copolymers comprising:

20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 of 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers; and

said core layer is disposed between said intermediate and said outer protective layers, and said film has a hot water seal strength of at least 200 seconds at 95°C.

Claim 112 (previously presented). A process for making biaxially stretched, heat shrinkable film comprising:

extruding a melt plastified primary tube comprising a polymeric blend A comprising 20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

cooling said primary tube;

reheating said cooled tube to a draw point temperature of 65 to 88°C;

biaxially stretching said tube to provide a transverse direction circumference of at least 2½ times the circumference of said primary tube and a machine direction length of at least 2½ times the length of a corresponding segment of said primary tube, and cooling said biaxially stretched tube to form a biaxially stretched, heat shrinkable film having a film thickness less than 10 mil (254 microns), wherein said resultant film has a ram puncture force of at least 70 Newtons, a ram puncture stress of at least 110 Mpa, and a tear propagation strength "x" such that $10 \leq x \leq 40$ grams per mil in each of the machine and transverse directions or $x < 25$ grams per mil in at least one of the machine and transverse directions.

Claim 113 (previously presented). A process for making biaxially stretched, heat shrinkable film comprising:

extruding a melt plastified primary tube comprising a polymeric blend A comprising 20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second

polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

cooling said primary tube;

reheating said cooled tube to a draw point temperature of 65 to 88°C;

biaxially stretching said tube to provide a transverse direction circumference of at least 2½ times the circumference of said primary tube and a machine direction length of at least 2½ times the length of a corresponding segment of said primary tube, and cooling said biaxially stretched tube to form a biaxially stretched, heat shrinkable film having a film thickness less than 10 mil (254 microns), wherein said resultant film has a ram puncture force of at least 120 Newtons, and a total energy absorption of at least 1.20 Joules.

Claim 114 (previously presented). A process for making biaxially stretched, heat shrinkable film comprising:

extruding a melt plastified primary tube comprising a polymeric blend A comprising 20 to 85 weight percent of a first polymer having a melting point of 80 to 98°C comprising at least one copolymer of ethylene and hexene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

cooling said primary tube;

reheating said cooled tube to a draw point temperature of 65 to 88°C;

biaxially stretching said tube to provide a transverse direction circumference of at least 2½ times the circumference of said primary tube and a machine direction length of at least 2½ times the length of a corresponding segment of said primary tube, and cooling said biaxially stretched tube to form a biaxially stretched, heat shrinkable film having a film thickness less than 10 mil (254 microns), wherein a multilayer primary tube is made by coextrusion or coating lamination and said resultant biaxially stretched film comprises:

a heating sealing surface layer comprising a polymer selected from the group consisting of:

(a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof, said polymer having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

an intermediate layer;

a core layer comprising at least 80% by weight (based on said third layer's weight) of at least one copolymer of: EVOH; or vinylidene chloride with from 2 to 20 weight percent (based on said copolymer's weight) of vinyl chloride or methyl acrylate; and

an outer protective surface layer;

wherein at lease one of said intermediate and said outer protective layers comprise said polymeric blend A and said core layer is disposed between said intermediate and said outer protective layers, and said film has a maximum ram puncture force of at least 100 Newtons, a hot water puncture resistance of at least 100 seconds at 95°C and a hot water seal strength of at least 200 seconds at 95°C.